

# Work Order ID 81665

**\*81665\***

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March-16-12 1:56:02 PM

Item ID: K10003 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, D205-634-011  
 Start Date: 16/03/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 30/03/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:



Approvals: Process Plan: MLJ Date: 12/03/16 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN634,635	G

100 DOCUMENT CONTROL 0.00  
**\*100\***  
 DC Memo 0.00  
 Document Control Create White labels only per PPP K10003 ~~CHG 007~~ CHG 010 Sir/ce/09

110 Pick Kit 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging  12/03/30

120 QC4- 100% Inspect kits for completeness 0.00  
**\*120\***  
 QC Memo 0.00  
 Quality Control  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81665

**\*81665\***

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Item ID: K10003

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, D205-634-011

Start Date: 16/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	<i>Phg</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*012/4/9*

*12/4/10*

*ME 12-04-09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: 1 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF  
 IPP: J 06-07-25 As per DSI 9344 JLM  
 IPP: K 06.11.17 Per K10003 Rev C KJ  
 IPP: L 07.01.12 Document Record for copying bluefile rny KJ  
 IPP Rev: M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:  
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev: O  
 11.03.11 per dsi9536 DD verf: EC IPP REV: P 12.01.23 AS  
 PER ECN11-684 VERF: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-51A *AN4-51A* Bolt		Purchased	No			110	Each	206.0000	8	32			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST361				206					
				119798				30					
				120187				126					
				120986				50					
AN4-6A *AN4-6A* Bolt		Purchased	No			110	Each	1,649.000	16	64			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST356				1649					
				119017				1649					
AN4C46A *AN4C46A* BOLT		Purchased	No			110	Each	32.0000	4	16			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST360				32					
				120334				32					

12/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

AN6-12A Purchased No

110 Each 171.0000

\*AN6-12A\*

Bolt

8 32 ✓  
\*\* 121185 JB

## Location

## Loc Qty

## Loc Code

ST341

171

120187

46

120423

125

120187

AN960JD416 / NAS1149D0463J Purchased No

110 Each 14.0000

\*AN960.ID416\*

Washer

32 128 ✓  
\*\* 121011 JB

## Location

## Loc Qty

## Loc Code

ST351

14

116289

14

AN960JD616 / NAS1149D0663J Purchased No

110 Each 0.0000

\*AN960.ID616\*

Washer

8 32 ✓  
\*\* 119510 JB 232

D2570 Manufactured No

110 Each 327.0000

\*D2570\*

Bushing

24 130644 90  
\*\* 119013 JB

## Location

## Loc Qty

## Loc Code

ST011

327

72960

41

78586

19

78587

67

79493

200

79493 -

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2571

Manufactured No

110

Each

18.0000

1 4

\*\*

\*D2571\*

Saddle, Fwd Out 205

Location

Loc Qty

Loc Code

ST

1

11644

1

ST425

-13

ST432

17

79977

5

80828

12

ST433

13

80828

D2572

Manufactured No

110

Each

14.0000

1 4

\*\*

\*D2572\*

Saddle, Fwd In 205

Location

Loc Qty

Loc Code

ST432

14

71107

2

80783

12

80783

D2573

Manufactured No

110

Each

11.0000

1 4

\*\*

\*D2573\*

Saddle, Aft Out 205

Location

Loc Qty

Loc Code

ST423

-12

79424

0

ST433

11

79717

5

80829

6

ST434

12

80829

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 4

Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D2574

Manufactured No

110 Each

11.0000

1 4 ✓

\*\*

JB SP

\*D2574\*

Saddle, Aft In 205

Location

Loc Qty

Loc Code

ST433

11

79718

5

80830

6

~~80830~~

Manufactured No

110 Each

138.0000

4 16 ✓

\*\*

JB SP

D2747

\*D2747\*

Set Screw

Location

Loc Qty

Loc Code

ST017

138

77484

38

79520

100

\*77484

Manufactured No

110 Each

95.0000

2 8 ✓

\*\*

JB SP

D2876

\*D2876\*

Saddle Spacer

Location

Loc Qty

Loc Code

ST020

95

79693

95

79693

Manufactured No

110 Each

45.0000

2 8 ✓

\*\*

JB SP

D2877

\*D2877\*

Saddle Spacer

Location

Loc Qty

Loc Code

ST020

45

78843

45

78843

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12/03/30  
Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D3405-041 Manufactured No

110 Each 15.0000 1 4 ✓

\*D3405-041\*

Lug Assembly

\*\*

JB SP

## Location

## Loc Qty

## Loc Code

ST478

15

62227

2

77000

2

78892

11

78892

D3405-043 Manufactured No

110 Each 16.0000 1 4 ✓

\*D3405-043\*

Lug Assembly

\*\*

JB SP

## Location

## Loc Qty

## Loc Code

ST423

2

65703

2

ST478

14

78889

12

78890

2

78889

D3407-041 Manufactured No

110 Each 12.0000 1 4 ✓

\*D3407-041\*

Tow Ring

\*\*

JB SP

## Location

## Loc Qty

## Loc Code

ST463

12

78877

12

78877

D3417-5 Manufactured No

110 Each 54.0000 2 8 ✓

\*D3417-5\*

Washer

\*\*

5X 82024 JB SP

## Location

## Loc Qty

## Loc Code

ST042

54

77684

13

78842

41

5X 77684

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Shop Packet Print

12/03/30

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 6

Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

D3456-1

Manufactured No

110

Each

83.0000

1

4

\*\*

\*D3456-1\*

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST034

12

77486

12

ST044

64

66848

3

71165

2

73493

9

80252

50

80252

D3533-1

Manufactured No

110

Each

90.0000

2

8

\*\*

\*D3533-1\*

Set Screw

Location

Loc Qty

Loc Code

ST053

90

80326

90

80326

MS21042L4

Purchased No

110

Each

5,519.000

24

96

\*\*

\*MS21042L4\*

Nut

Location

Loc Qty

Loc Code

ST300

5519

117441

51

117601

157

118451

133

119017

200

119075

2978

121011

2000

119075

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Shop Packet Print

12/03/30  
Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 81665

\*81665\*

Parent Item: K10003

\*K10003\*

Parent Item Name: Saddle, D205-634-011

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

110

Each

1,148.000

5

20

✓

\*MS21043-4\*

\*\*

23 [Signature]

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1108

119546

370

120308

738

120308

March-16-12 1:56:07 PM

Shop Packet Print

12/03/30

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
1			X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
1	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

\*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

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Revision: G

Date: 11.06.24

# Work Order ID 81665

**\*81665\***

Page 1

March-16-12 1:56:02 PM

Item ID: K10003

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, D205-634-011

Start Date: 16/03/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date: 12/03/16

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN634,635

G

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003

CHG 007

*010  
see attachment*

*MLC 12/03/30  
(4)*

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

(K10003 Prop kit)

## Change Record

Part Number D205-634-011 / 011DG  
Description 205/212/412 SIKOTUBE

Page 1 of 1

Chg.	Date	By	Relevant Documents
001	N/A	CP	D205-634-041 CHG 001 K10003 CHG 001
002	09.04.28	CP	D205-634-041 CHG 001 K10003 CHG 002 (SADDLE SPACERS)
003	00.03.08	DS	D205-634-041 CHG 001 K10003 CHG 003 (TOW RING)
004	02.09.25	DS	D205-634-041 CHG 001 K10003 CHG 004 (SHOULDER)
005	07.07.04	fy	MDL-D205-634 Rev.B
006	08.08.01	fy	MDL-D205-634 Rev.D (ECN 08-507)
007	08.12.22	fy	DS1 9417 Rev.B, D3404 Rev.C, D3405 Rev.B (ECN 08-588)
008	10.11.18	fy	DS1 9519 Rev.B, D4202 Rev.A, DEO-D2580, 2590 Rev.D (ECN 10-645)
009	11.03.31	fy	D4202 Rev.B (ECN 11-543)
010	11.12.15	fy	DEO-D2580-E-1, DEO-D2590-E-1, D4202 Rev.C, (ECN 11-684)